Qty:

Date:

. f

Tuesday, 11/29/2005 4:40:05 PM

User:

Linda Lacelle

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 25030

Estimate Number

: 10812

P.O. Number

Written By

This Issue

: 11/29/2005 Prsht Rev.

: NC

First Issue **Previous Run**

: 24895B

: //

: MACHINED PARTS Type

S.O. No. :

Drawing Name

Part Number Drawing Number : D3178041 : D3178 REV. A

: NUT PLATE ASSEMBLY

Project Number Drawing Revision

: N/A : A

Jule

Material

Due Date

: 12/9/2005

20 Um:

Each

Comment **Additional Product**

Checked & Approved By

Job Number:



Seq. #:

1.0

Machine Or Operation:

M5052H32S063

: Est:B 03\02.28

Description:

5052-H32 .063 Sheet

Comment: Qty.:

0.0365 sf(s)/Unit Total: 0.7308 sf(s)

Material: 5052-H32/H34 (QQ-A-250/8) 0.063 thick

(M5052H32S.063)

Batch:

SHEA

Modify Step 1,2,3,4,21,23 KJ/RF

2.0 SHEAR



Comment: SHEAR

Cut blanks: 3.00" x 1.520"

3.0

HAAS1

HAAS CNC VERTIGAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA296 and Dwg D3178

Identify as D3178-1

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

SECOND CHECK



Comment: SECOND CHECK





Dart Aerospace Ltd

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NOTE: Date & initial all entries

/Date: Tuesday, 11/29/2005 4:40:05 PM User: Linda Lacelle **Process Sheet** Drawing Name: NUT PLATE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 25030 Part Number: D3178041 Job Number: Seq. #: **Machine Or Operation:** Description: SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- C'sink D3178-1 holes as per Dwg D3178 2- Deburr 7.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT CHEMICAL CONVERSION COAT MS20426AD34 10.0 RIVET Comment: Qty.: 8.0000 Each(s)/Unit Total: 160.0000 Each(s) **RIVET** Pick: Qty Part Number Description Batch MS20426AD3-4 Rivet 11.0 MS21059L3 Nut Plate

Comment: Qty.:

4.0000 Each(s)/Unit Total: 80.0000 Each(s)

Nut Plate

Pick:

Part Number

Description

Batch

MS21059L3

Nut Plate

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3178



Dart Aerospace Ltd

W/O:	•	· ·				NOR	(ORDE	R CH	ANGE	S		- . •	•••		
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NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 4:40:05 PM User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: NUT PLATE ASSEMBLY**

Job Number: 25030

Part Number: D3178041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Sur 05/12/14

Job Completion



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W/O:		WORK OF	RDER CHAI	NGES					i un generalista k
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<i>x</i>		Description of NC		Corrective Action Section B	Verification	A	Annaval			
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Nut Plate	Part Number:	D3178-1
Inspection Dwg: D3178 Rev: A		Page 1 of 1

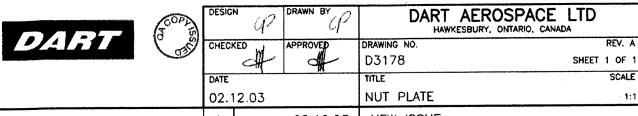
FIRST ARTICLE INSPECTION CHECKLIST

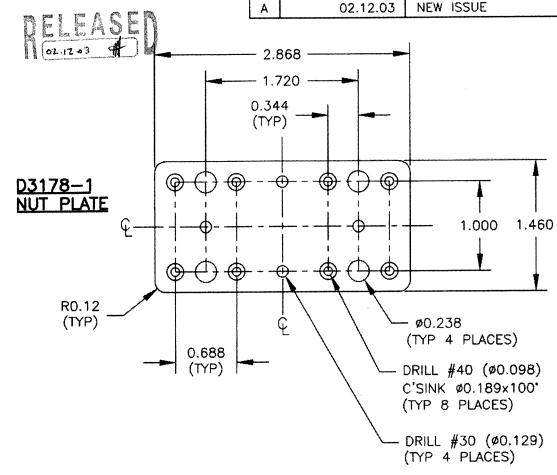
X First Article Prototype

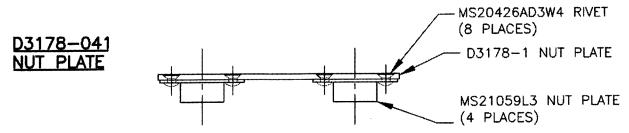
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.868	+/-0.010					
1.460	+/-0.010					
1.720	+/-0.005					
0.344	+/-0.005					
1.000	+/-0.005					
0.688	+/-0.005					
R0.12	+/-0.030					
Ø0.238	+0.005/-0.000					
Ø0.098	+0.005/-0.000		1			
Ø0.129	+0.005/-0.000					
0.063	+/-0.010					

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue	KJ/RF	







NOTES, D3178-1 NUT PLATE:

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)

(REF DART SPEC. M5052H32S.063)

- 3) BREAK ALL SHARP EDGES 0.005-0.010
 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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